



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5101-041
Job Sheet 199117



Part No: D5101-041

Job Qty: 10 pcs

Part Name: Crossbolt Spacer Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 9/17/19

Description:

Type: Stock

Note: DWG REV C SHEETS 1,2 IPP REV:A NEW ISSUE 14-12-18 JLM VERIFIED BY:DD IPP REV:B 15.12.10 AS
PER DWG REVB DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	9/17/19	9/17/19	0.00	0.53	Bandsaw - 1		19-08-30
110	HAAS 5 Axis - B4B	10 pcs	9/17/19	9/17/19	0.75	2.77	HAAS - 5 - B4B		
120	QC 2	10 pcs	9/17/19	9/17/19	0.00	0.00	QC 2 - 1		19-08-30
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



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CANADA
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Container No: S210627



Part: D5101-041

Job No: 199117

Serial No/Batch: S210627

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/30/19

Plex 8/13/19 9:12 AM Dart.Renwick.Jennifer

130 QC 8	10 pcs	9/17/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	MK 19/08/31
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - 2 - B4B	10 pcs	9/17/19	0.00 1.91	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	SEP 03 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
170 QC 5	10 pcs	9/17/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	SEP 03 2019
				QC 5 - 61	
				QC 5 - 81	

180 Packaging 3-1 - Stock - B4B 10 pcs	9/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	41 19-9-3
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	9/17/19	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 53

DAB
21
9-59
SEP 03 2019

Part Op 100 - Bandsaw

Descriptions: 110 - HAAS CNC vertical machine #5

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Small Fab

170 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNB1.000X4.000	Delrin Bar	2 ft (2 ea)	100-Bandsaw - 1	5178 110 8097485
MS21209F7-10	Heli-Coil, Locking	40 Ea (4 ea)	140-Small Fab - 2 - B4B	

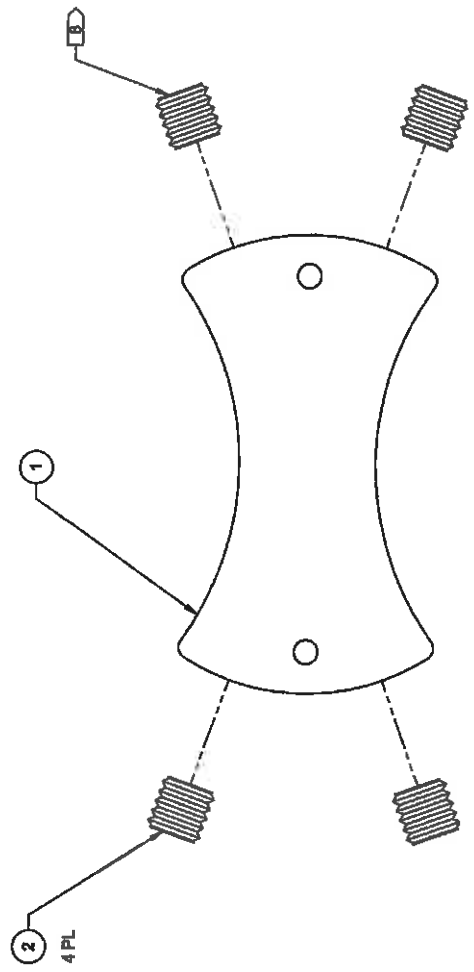
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRLNB1.000X4.000	2	24	0
140-Small Fab - 2 - B4B	MS21209F7-10	40	119	0

Part Specifications
Specifications could not be found.

Plex 8/13/19 9:12 AM Dart.Renwick.Jennifer

ITEM	QTY	PIN	DESCRIPTION
	441		
	X	D5101-041	CROSSBOLT SPACER ASSY
1	1	D5101-1	CROSSBOLT SPACER
2	4	MS21208F7-10	HELICOIL, LOCKING



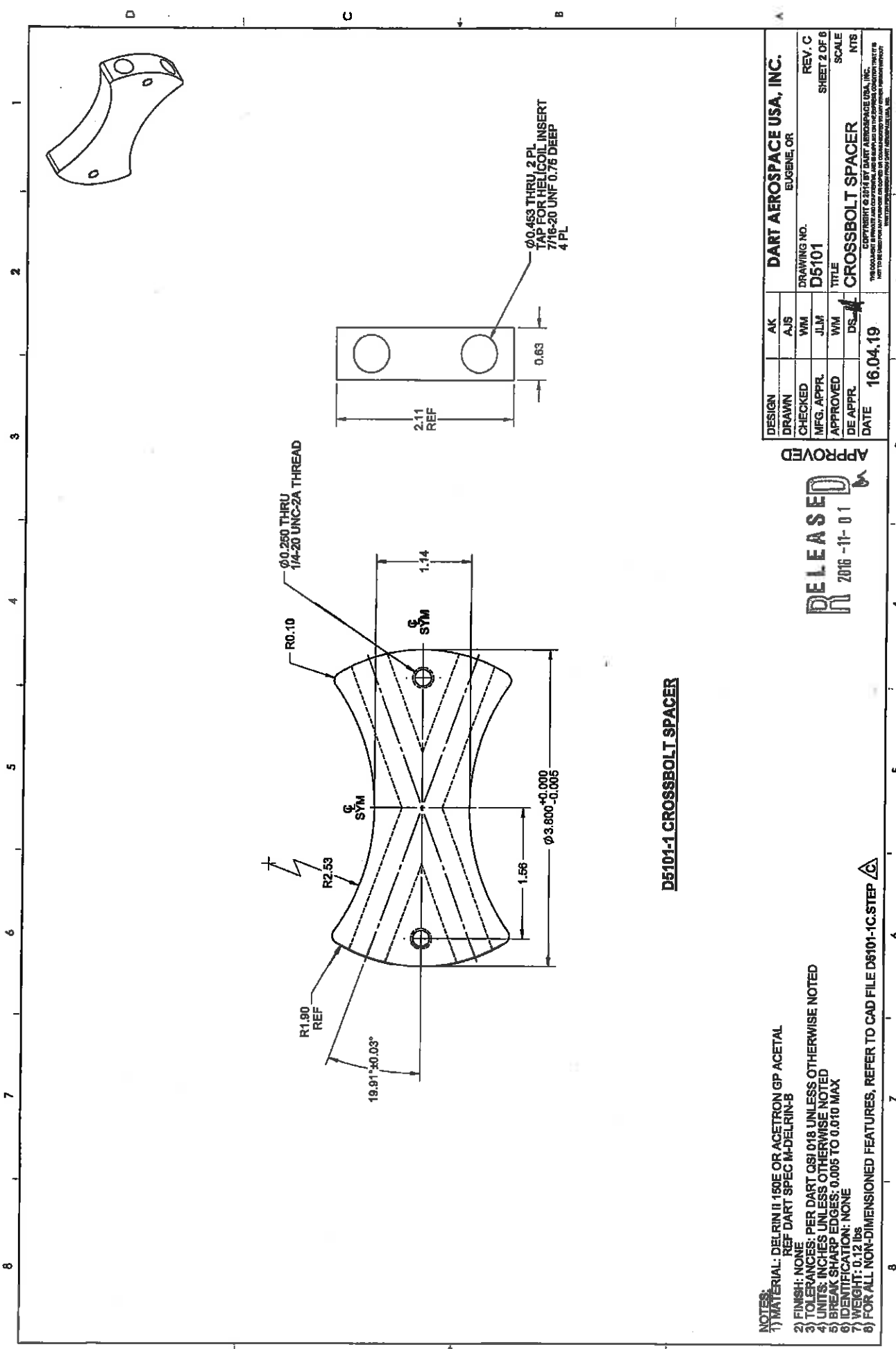
D5101-041 CROSSBOLT SPACER ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
 - 7) WEIGHT: 0.14 lbs
 - 8) INSTALL MS21208F7-10 HELICOIL ONE FULL REVOLUTION BELOW SURFACE

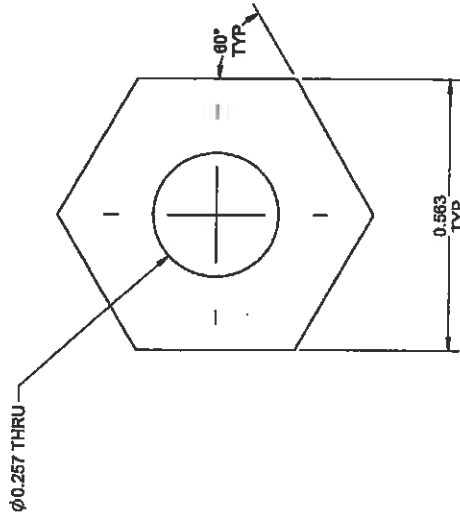
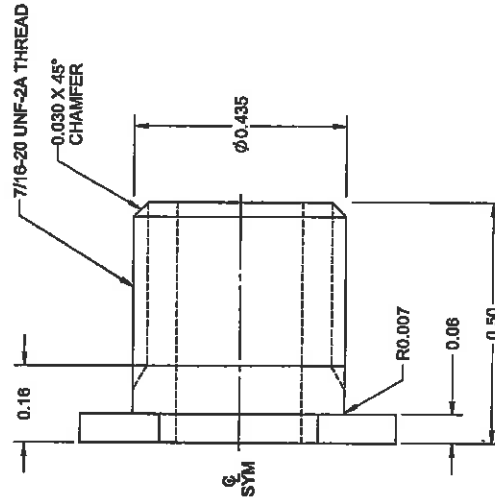
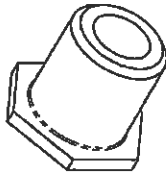
RELEASED
 2016-11-01
 2016-11-01

APPROVED

C	SHEET 2: ADDED NOTE 8, SHEET 6: R1.85 WAS R1.80, 0.18 WAS 0.17, 3.876 WAS 3.880.			DB / AJS	16.04.19
B	REVISED NOTE 6 (SH 1, 2 & 4) & NOTE 9 (SH 1). REVISED HELICOIL SPECIFICATIONS TO ADD D5101-041 (SH 10A). REMOVE 0.088 HOLES FROM -1, MS21208F7-10 WAS MS21208F7-16.			DB	15.10.15
A	NEW ISSUE			AK	14.08.07
REV.	DESCRIPTION			BY	DATE
DESIGN	AK				
DRAWN	AJS				
CHECKED	WM				
MFG. APPR.	JLM				
APPROVED	WM				
DE APPR.	DS				
DATE	16.04.19				
DART AEROSPACE USA, INC.					
EUGENE, OR					
DRAWING NO. D5101					
TITLE CROSSBOLT SPACER					
SHEET 1 OF 6					
SCALE					
NTS					
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NOTES:				DART AEROSPACE USA, INC.			
1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL				DESIGN	AK	EUGENE, OR	
2) FINISH: NONE				DRAWN	AJS	DRAWING NO.	REV. C
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED				CHECKED	WM	D5101	SHEET 2 OF 8
4) UNITS: INCHES UNLESS OTHERWISE NOTED				MFG. APPR.	JLM	TITLE	SCALE
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX				APPROVED	WM	CROSSBOLT SPACER	NTS
6) IDENTIFICATION: NONE				DATE	16.04.19	DATE	16.04.19
7) WEIGHT: 0.12 lbs				DART AEROSPACE USA, INC.			
8) FOR ALL NON-DIMENSIONED FEATURES, REFER TO CAD FILE D5101-1C.STEP				THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY OTHER REASON			



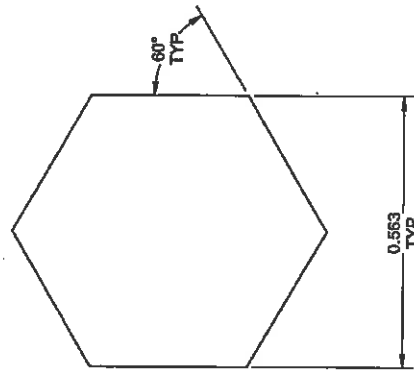
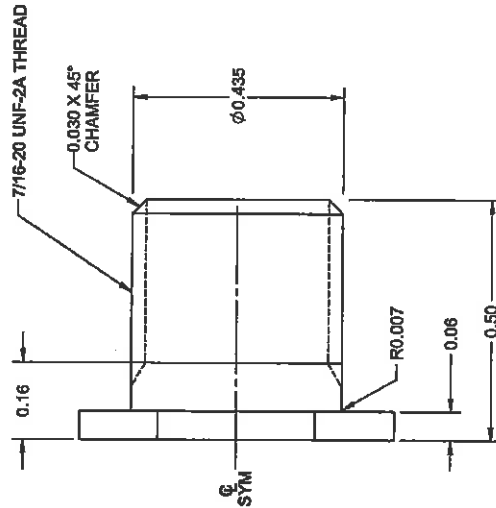
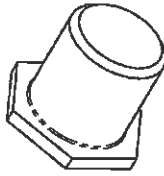
D5101-3 INSERT

- NOTES:**
- 1) MATERIAL: 6061-T6/7050-T6/7050-T6 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4174/128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8
(OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 003 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
 - 7) WEIGHT: 0.005 lbs

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2016-11-01

DESIGN	AK	DART AEROSPACE USA, INC.
DRAWN	AJS	EUGENE, OR
CHECKED	WM	DRAWING NO. D5101
MFG. APPR.	JLM	REV. C
APPROVED	WM	SHEET 3 OF 8
DATE	16.04.19	TITLE CROSSBOLT SPACER
		SCALE NTS

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D5101-5 INSERT

- NOTES:
- 1) MATERIAL: 8061-T87051/T8510/T8511/T82 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8
(OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M0081T6R
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
 - 7) WEIGHT: 0.008 lbs

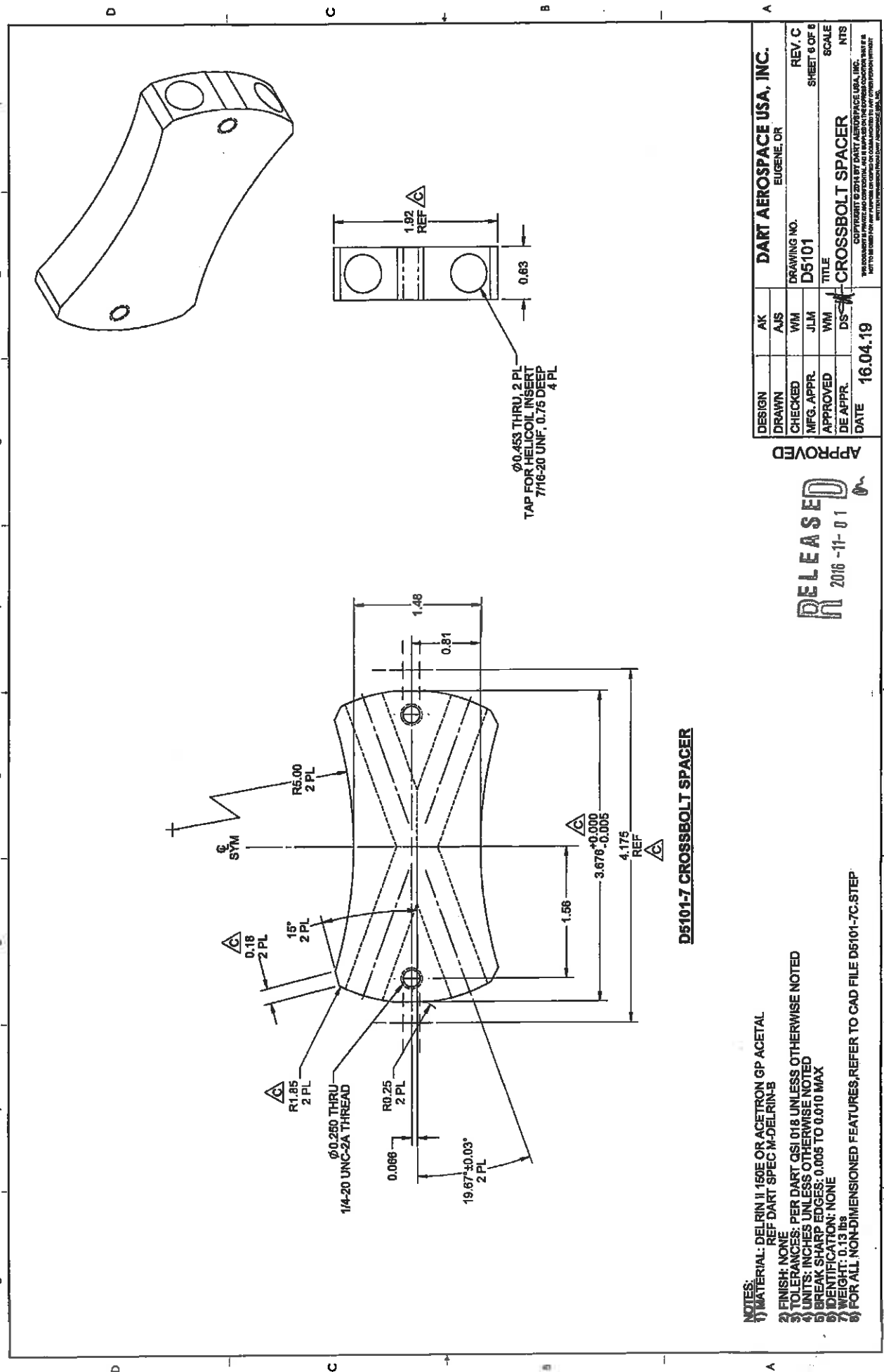
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2016-11-01

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DRAWN	AKS	EUGENE, OR
CHECKED	WM	DRAWING NO. D5101
MFG. APPR.	JLM	REV. C
APPROVED	WM	SHEET 4 OF 6
DE APPR.	D8	TITLE CROSSBOLT SPACER
DATE	16.04.19	SCALE NTS

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2 3 4 5 6 7 8



- NOTES:
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
REF DART SPEC M-DELRIN-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs
 - 8) FOR ALL NON-DIMENSIONED FEATURES, REFER TO CAD FILE D5101-7C.STEP

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CHECKED	WM	DRAWING NO. D5101
MFG. APPR.	JLM	REV. C SHEET 6 OF 8
APPROVED	WM	TITLE CROSSBOLT SPACER
DE APPR.	DS	SCALE NTS
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D5101-7 CROSSBOLT SPACER

